

**Work Order ID 70562**

Monday, June 13, 2011 10:06:24 AM



Page 1

Item ID: D350-591-214

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop



Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:   *RP*  Date: 11-06-13

Tooling:



Date:           

Run Start

QC:           Date:           SPC (Y/N):           Date:           

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3078	A								
DSI 9472	A								
100		0.00							
	DOCUMENT CONTROL								
DC									
Document Control	<b>Memo</b> Photocopy bluefile and type labels as per PPP D350-591-214 CHG003	0.00							
			<i>8u17/13</i>						<i>49 Circ 11-7-12</i>
110		0.00							
	Large Fab								
Large Fab									
Large Fab	<b>Memo</b> 1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets. 3-Deburr	0.00							
			<i>11.06.22</i>				<i>4</i>	<i>φ</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Monday, June 13, 2011 10:06:24 AM

Page 2

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Revision ID:

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Start Date: 6/10/2011 Start Qty: 4.00

Required Date: 6/22/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Sub 6/22



130



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Bevel end for welding FWD ONLY  
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3078  
A/RAluminum Rod M114703  
3-Grind End Plate flush M117884

11.06.22 4

H/Ae 11.06.29 4

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4 0 11/06/29

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200



Large Fab

Large Fab

Large Fab

Memo

1- Rivet Leg Assembly as per Dwg D3078.

2-Bevel Aft end for welding

3-Inspect for foreign object as per QSI 024

4-Weld Aft End Plate as per QSI 004 &amp; Dwg D3078

A/R Aluminum Rod M114703

5-Grind End Plate flush

0.00

0.00

0.00

0.00

210



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

11.07.06  
AC 11.07.06

5/10/08

4  
x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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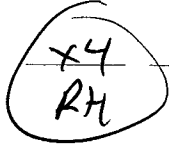


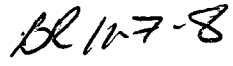

Monday, June 13, 2011 10:06:24 AM



Page 5

Item ID: D350-591-214 Accept  Setup Start   
Revision ID:  
Item Name: Heli-Access-Step, Short RH Stop   
Start Date: 6/10/2011 Start Qty: 4.00  Cust Item ID:  
Required Date: 6/22/2011 Req'd Qty: 4.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
230  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
240  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo	0.00 0.00							

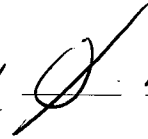
Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

12:50  
320 OF  
1:20

4RHX  m/11/07/11

m 11775

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, June 13, 2011 10:06:24 AM

Page 6

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250

Wing Walk as per dwg QSI005 4.4 Batch *M117863*

HandFinish

Memo

0.00

Hand Finishing

*4. 0 BR 11-7-12*

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*4 RH 0 11-7-12*

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*11/12(13) SL (4)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 7

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Setup Start



Revision ID:

Item Name: Heli-Access-Step, Short RH

Stop



Start Date: 6/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/22/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280



QC

Quality Control

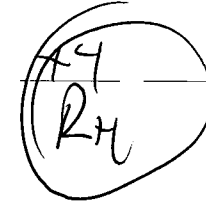
QC4- 100% Inspect kits for completeness

0.00

8/17/13

Memo

0.00



290



Packaging

Packaging

Packaging

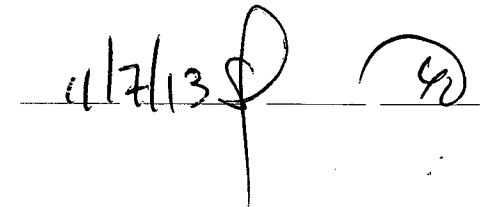
0.00

Memo

Identify and pack for shipping as per PPP D350-591-214

Location: 80E  
PPP Rev: 80E

0.00



300



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/14  
ME 11-07-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Monday, June 13, 2011 10:06:30 AM

Page 1

Work Order ID: 70562

Parent Item: D350-591-214

Parent Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D  
 10.11.15 update qty on AN4-11A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C



Step Extrusion

Manufactured No

110

Each

35.7000

0.5

2



11.06.22

Location

Loc Qty

Loc Code

HALL

368293

6

2

64409

6

WA

29.7

46910

2

66970

27.7

D3063-1



Support

Manufactured No

130

Each

34.0000

1

4



11.06.22

Location

Loc Qty

Loc Code

WA

20

66182

20

WA016

14

59663

14

4

D3067-1



End Plate

Manufactured No

130

Each

87.0000

1

4



11.06.22

Location

Loc Qty

Loc Code

WA

2

67582

2

WA016

85

68214

85

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, June 13, 2011 10:06:30 AM

Page 2

Work Order ID: 70562



Parent Item: D350-591-214



Parent Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

D3066-1 Manufactured No

200 Each

101.0000

2

8



Spacer



11.07.06

Location

Loc Qty

Loc Code

WA

101

68337

20

69738

81

MS20600-AD4W4

Purchased

No

200

Each

2,064.000

16



Rivets



8

11.07.06

Location

Loc Qty

Loc Code

ST321

2059

116188

59

117364

1000

117601

200

117885

800

WA018

5

116712

5

D3065-041

Manufactured

No

200

Each

44.0000

1

4



Step Leg Assembly Hi



11.07.06

Location

Loc Qty

Loc Code

WA

44

66149

0

67503

4

69740

40

x4

W/O:		WORK ORDER CHANGES					
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Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

D3067-1

Manufactured No

200 Each

87.0000

1

4



End Plate



11.07.06

Location

Loc Qty

Loc Code

WA

2

67582

2

WA016

85

68214

85

AN4-16A

Purchased No

270 Each

252.0000

4



Bolt



4/16

Location

Loc Qty

Loc Code

ST358

252

116400

52

117514

100

117872

100

D2732

Manufactured No

270 f

233.3281

1

4



Rubber Extrusion



11/7/13

Location

Loc Qty

Loc Code

ST410

233.32811

64283

233.32811

Cut 3.00" long, qty 4

AN3-35A

Purchased No

270 Each

117.0000

2

8



Bolt



11/7/13

Location

Loc Qty

Loc Code

ST353

117

117441

17

117619

50

117794

50

Monday, June 13, 2011 10:06:31 AM

Shop Packet Print

Page 3

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Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-11A

Purchased

No

270

Each

274.0000

2

8



Bolt



*SL*

Location

Loc Qty

Loc Code

ST356

100

117872

100

ST357

174

110382

1

115316

173

AN960JD416

NAS1149D0463J

Purchased

No

270

Each

0.0000

12

48



Washer

D2230-3

Manufactured

No

270

Each

34.0000

2

8



Lug



*8*  
*32x42*  
*M118078*  
*M117460*  
*M117291*  
*B70694*  
*SL*

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

30

68246

30

D2856-400

Manufactured

No

270

f

121.6696

0.6

2.4



Abraison Strip



*11/2/13*  
*SL*  
*40*

Location

Loc Qty

Loc Code

ST403

121

68076

121

ST409

0.6696

63735

0.6696

cut 7.20" long, qty 1

*measured*  
*SW 7113*

Monday, June 13, 2011 10:06:31 AM

Shop Packet Print

Page 4

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Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

270

Each

2,290.000

2

8



Nut

Location

Loc Qty

Loc Code

ST300

2290

116391

9

116549

581

117441

800

117601

400

117885

500

AN4-13A

Purchased

No

270

Each

306.0000

4

16



Bolt

Location

Loc Qty

Loc Code

ST357

306

117962

306

D2230-1

Manufactured

No

270

Each

142.0000

2

8



Lug

Location

Loc Qty

Loc Code

ST476

142

67761

36

67826

6

69179

100

MS21042L4

Purchased

No

270

Each

5,203.000

6

24



Nut

Location

Loc Qty

Loc Code

ST300

5203

117441

2903

117601

800

117885

1500

Monday, June 13, 2011 10:06:32 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Monday, June 13, 2011 10:06:32 AM

Page 6

Work Order ID: 70562



Parent Item: D350-591-214



Parent Item Name: Heli-Access-Step, Short RH

Start Date: 6/10/2011

Required Date: 6/22/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD10

NAS1149D0363J Purchased

No

270

Each

0.0000

4

16



Washer



M117291

11/8/13 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.01.20 *#*

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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70562

*PL11-06-13*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

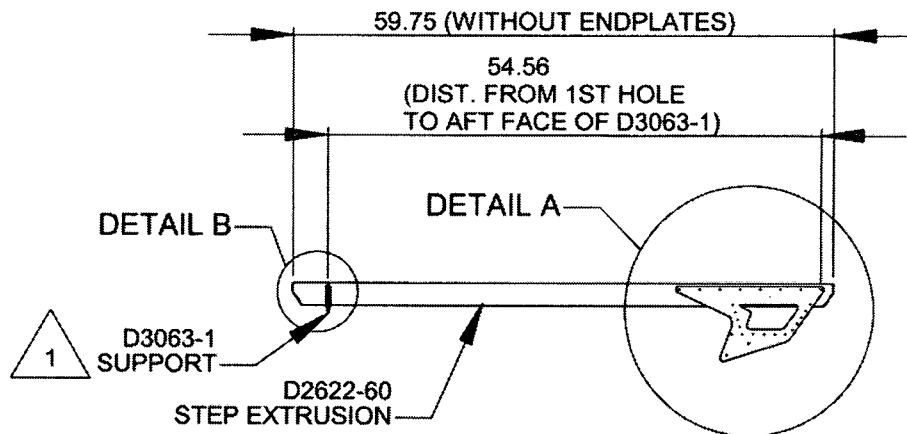


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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	REV. A
DATE 02.09.11	DRAWING NO. D3078	SHEET 2 OF 2
	TITLE STEP ASSEMBLY, HI SHORT	SCALE 1:20

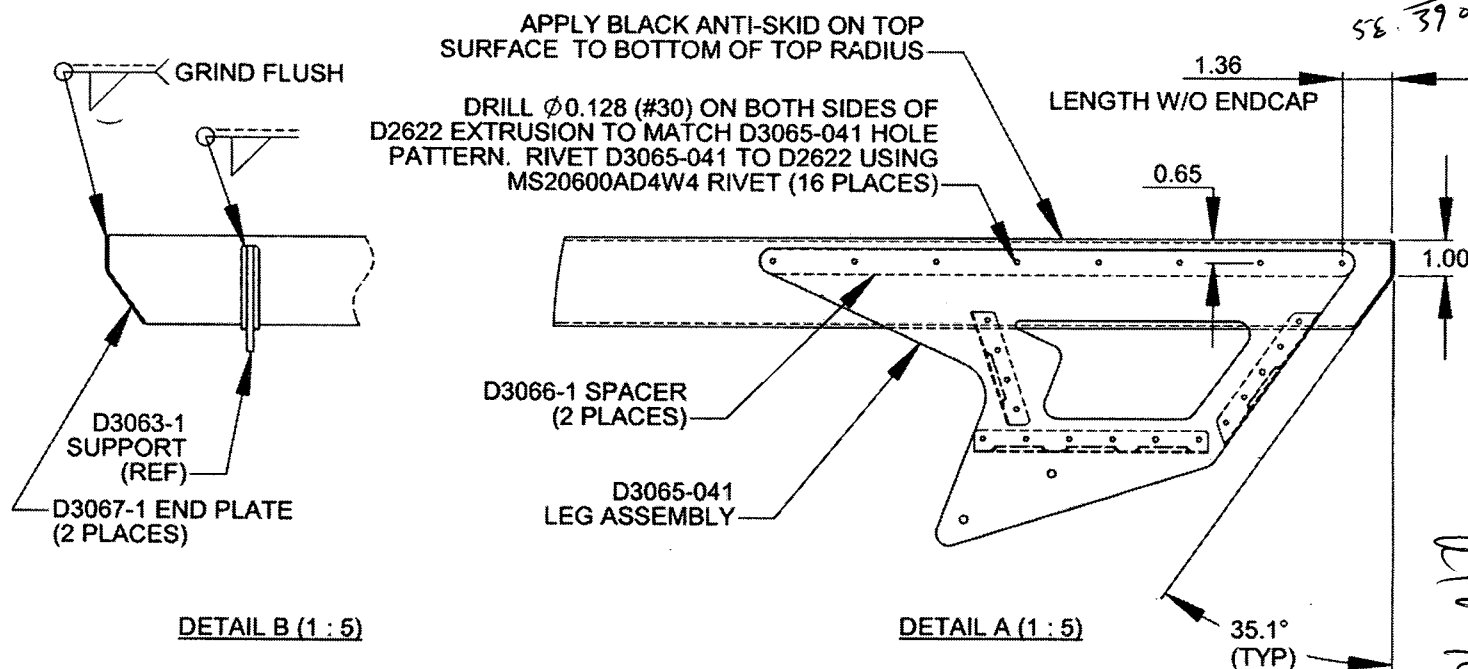
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58.39

U/V 10508



D.O.C.



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	*MOUNTING LUG
		2	2	2	2	4	4	D2230-3	*MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	*CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	*BOLT
		4	4	4	4	8	8	AN4-13A	*BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	*WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

# REFERENCE ONLY

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:





### ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<del>Heli-Access-Step</del> ™, Short Step – High Skid, LH
	X			D350-591-214	<del>Heli-Access-Step</del> ™, Short Step – High Skid, RH
		X		D350-591-215	<del>Heli-Access-Step</del> ™, Short Step – Low Skid, LH
			X	D350-591-216	<del>Heli-Access-Step</del> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 09.08.05  
CERT. NO.: SH92-6  
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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